

Date: Tuesday, 02/06/2009 3:55:10 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: RIB		
Job Number	: 48318			Part Number	: D22211		
Estimate Number	: 13673			Drawing Number	: D2221 REV H (PG.5)		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/06/2009	S.O. No.	:	Drawing Revision	: H		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 09/06/2009	Qty:	8 Um: Each
Previous Run	: 48101						
Written By	:						
Checked & Approved By	: <u>Julie Dawson</u>						
Comment	: Est Rev:A New Issue 08-12-02 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Scrap End Bar min ⁸⁸⁵ / ₉₈₄ = 2fs	
		Comment: Qty.: 8.4000 f(s)/Unit Total: 67.2000 f(s) 304 SQ Tube .75x.75x.065W batch: <u>min</u> ⁹⁸⁴ / ₈₈₅	SAD 09-06-05
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2221 2- Deburr and remove identification markings on tube	SAD 09-06-05
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>09/06/08 (78)</u>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Basket cell</u>	SAD 09-06-08 (6)
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	<u>09/06/08 (11)</u>
	Job Completion		 MF 09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

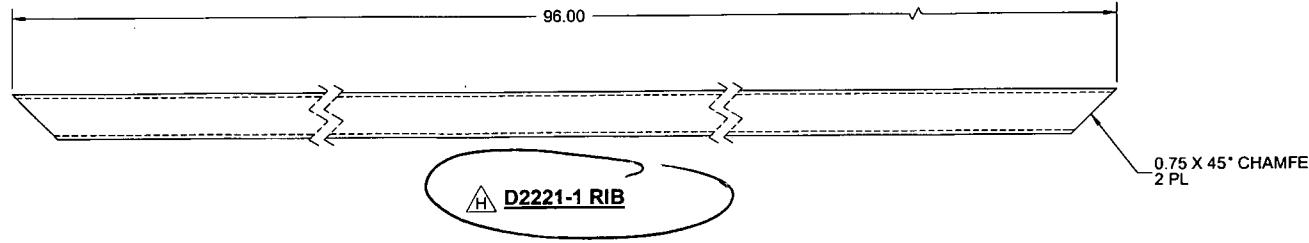
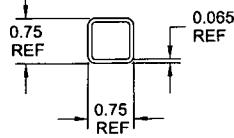
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

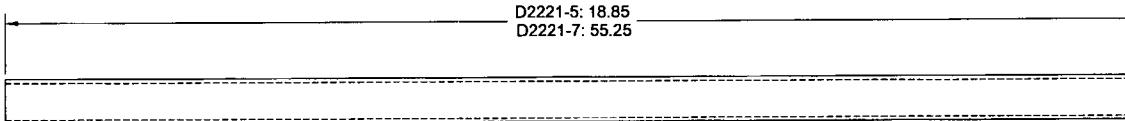
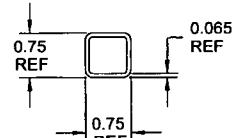
D

D



C

C



B

B

NO. 248318
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED
06/11/16 WD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. H	
MFG. APPR.	AS	DRAWING NO.	
APPROVED	NO	D2221	SHEET 5 OF 5
DE APPR.	MM	TITLE	SCALE
DATE	08.09.18	BASKET BASE ASSEMBLY (350) NTS	

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